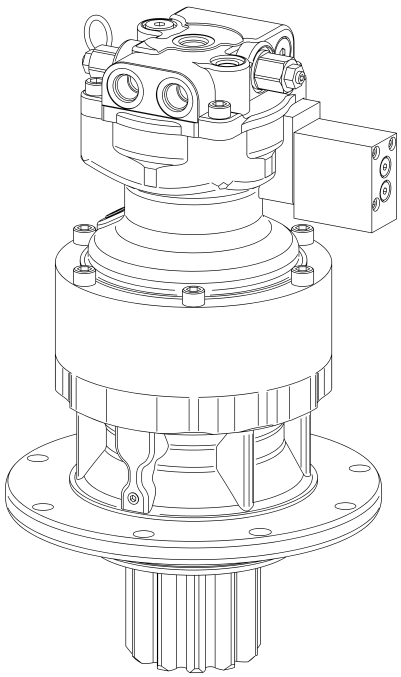
SG Series

Hydraulic Motor with Reduction Gear

Operation Manual



Please be sure to read and understand this manual before using the product.
The administrator and operator of the product should have access to this manual.
Store this manual at a specified safe place so that it can be referred to when necessary.

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CONTENTS OF MANUAL

This manual consists of the following chapters and references.

Chapter name		Description
IMPORTANT NOTICE		The following are explained: ・ Intended use of the product ・ Safety precautions ・ Notice on the Operation Manual ・ Disposal of SG ・ Other important notices
Ch.1	SAFETY	The information on safety is described as strict observance and prohibition. Safety information such as SG installation is described in Chapter 3 and later.
Ch.2	OVERVIEW OF SG	The name of each part of SG as well as how to store it described.
Ch.3	PREPARATION	Installation environments of SG, preparation of necessary materials, unpacking, and hoisting are described, along with safety precautions.
Ch.4	INSTALLATION	Installation procedure of SG, and precautions to avoid human injuries during installation as well as damage of SG.
Ch.5	HYDRAULIC OIL, LUBRICANT AND GREASE	The following information on hydraulic oil, lubricant and grease is described: ・ Precautions for handling ・ Recommended brand ・ Filling volume ・ Replacing interval and procedure
Ch.6	MAINTENANCE & INSPECTION	Precautions for maintenance and inspection works, and procedure of periodical inspection and SG removal are described.
Ch.7	TROUBLESHOOTING	How to deal with problems is described.
CUSTOMER SUPPORT		Support contact at our corporation is described.

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IMPORTANT NOTICE

1. Intended Use of Product

SG Series; Hydraulic Motor with Reduction Gear (hereafter referred to as SG) is a hydraulic driven rotary actuator. The product contains a reduction gear, a hydraulic motor and a parking brake integrated into one compact unit. It has been developed for use as a shaft output type actuator for driving the upper rotating body of construction machinery which requires low-rpm, high torque operation.

The following conditions are to be satisfied for the use of SG.

- SG should be used within the specifications and the limitations specified by our corporation. (Specifications and the limitation should be in compliance with those in confirmation notice (that is equivalent to delivery specification sheet) for SG or the specifications and operating agreement on the machinery for which SG is used.)
  - If it is used beyond the limitation range, it may cause abnormal wear due to poor lubrication or may cause damage due to seizure.
  - If SG is operated continuously at a high temperature, or at high load or at high rotation speed, the life or performance decline and damage may occur.
  - SG is not intended for the use in a series circuit, and problems related to the use in a series circuit are not our responsibility.
- The product should be properly assembled in the customer's equipment. (Refer to p.14 in Chapter 4.)
- The proper lubrication condition should be maintained. (Refer to p.18 in Chapter 5.)
- The product should be installed in the environmental condition specified by our corporation. (Refer to p.10 on 3.1. in Chapter 3.)
- Make sure SGs of the same type are used when applying them facing each other or synchronizing.
  - To prevent damages of SG and the machinery, do not use SG of other type or other manufacturer's product.
- The following precautions should be observed:
  - When the end user is concerned with military or when the intended use is the manufacture of arms, the product may be regarded as an object of export regulation according to the Foreign Exchange and Foreign Trade Act in Japan. When exporting the product in this case, prepare review and necessary procedures.
  - Prepare an oil tray to prevent the lubricant or grease from leakage due to malfunction or deterioration.

2. Precautions for Safe Use of SG

- Be sure to read this manual before use of SG.
- NOTICE that this manual cannot cover all of the precautions related to safety. In transportation, installation and maintenance of SG, ensure to observe general safety precautions.
- To prevent accidents, use the product only for the intended purpose. Avoid installation and maintenance work not specified or recommended in this manual.
- Do not disassemble, repair, or modify the product, as it may cause malfunction or failure of the product. If disassembly or repair is necessary, contact our customer support. (Refer to p. 31)
- Not only workers but also administrators should try to avoid any accidents.
- The installation and maintenance of the product should be performed only by personnel with at least basic knowledge of the hydraulic motor and reduction gear and who have fully read and understood this manual.

- Use of SG out of the intended use or without understanding the contents of this manual may cause the following hazard:
  - Hazard to life and health of the user
  - Breakage of SG or the machinery incorporating SG
- Wear hand protection such as leather gloves, prior to the handling because there is a risk of injury due to edges of the product that are not intended for manufacturing.
- When an operation qualification is required to operate equipment with SG installed, installation of SG in equipment and operation of equipment necessary for maintenance and inspections must be performed by a qualified person.

3. Notice on the Operation Manual

- This manual is intended for workers who are fluent in English. If this product is going to be operated or serviced by workers who are not fluent in English, the responsibility falls on the customer to provide thorough training on operation and safety.
- Ensure to operate the product according to the procedure and precautions specified and recommended in this manual. Any operation neglecting the described specification or recommendation may cause accidents and/or damage.
- This manual is copyrighted and all rights are reserved by our corporation. Any part of the drawings and technical references including in this manual shall not be copied, photocopied, or reproduced to any electronic medium or machine-readable form without prior consent of our corporation.
- The photographs and drawings described in this manual may not represent actual products strictly.
- If this manual is lost or damaged, immediately contact our customer support. Operating or servicing the product without this manual may result in accident.
- If you are going to transfer the product or machinery (attached or assembled in any way) to another party, be sure to submit this manual and related document to the new user.
- Reflect at least the description on hydraulic oil, lubricant and grease (Chapter 5) and maintenance & inspection (Chapter 6) in this document to the operation manual for the customer machine into which SG is incorporated.

4. Disposal of SG

Disposal of SG and packaging materials may be regulated by laws and regulations in each country / region.
In addition, recyclable materials are required to be reused.
When disposing, ask an industrial waste disposal contractor and follow these regulations.
If there is anything uncertain, please contact our customer support for processing.

5. Other Important Notice

- It is prohibited to analyze and use the product by any measure of reverse engineering or other related technology.

Chapter 1 SAFETY

The safety precautions are to be guidelines to avoid human accidents during the transportation, installation, and maintenance of SG, as well as to avoid damage to SG.

1.1. Strict observance and Prohibition

Overall precautions are classified into strict observance and prohibition.

For precautions at installation and maintenance, be sure to refer to the description of the corresponding chapter.

● Strict observance

- The transportation, installation, and maintenance should be performed only by personnel who understand the manual.
- The tools required for the work should be cleaned up to a specified place after work. Mixing a foreign object such as tools, screws and/or nuts may cause damage to the product.
- For handling of the hydraulic oil, the lubricant and grease, refer to the indications and recommendations in this manual.

● Prohibition

- The work coordinator and/or administrator should not let personnel perform the work without ample knowledge of the product. It may result in an injury to the operator or damage to the product.
- Do not put fingers or any foreign object at the opening end of the product. It may result in serious or moderate injury.
- Do not modify or disassemble the product. It may result in breakage of the product.
- Do not apply excessive impact or vibration to the product. It may cause breakage of the product.
- The product may be very hot during operation. After the operation, do not touch the product until it has cooled down. Otherwise it may result in a heat-related injury.
- Do not perform rapid cooling for high-temperature SG. When cooling, perform air cooling by atmospheric air.
- Do not put any inflammable object around the product. It may result in fire.
- If any abnormality or breakage should occur in the product, do not operate it until a proper countermeasure is prepared.

1.2. Types of Warnings and their Meanings

The following four types of warnings are used according to the expected hazards during operation and maintenance of the product. Neglecting such safety rules and warnings may cause accidents, resulting in serious injury and/or damage to this product.

Signal word	Meaning
⚠ DANGER	Indicates an imminently hazardous situation which, if not avoided or prepared protection measures, will result in death or serious injury.
⚠ WARNING	Indicates a potential hazardous situation which, if not avoided or prepared protection measures, could result in death or serious injury.
⚠ CAUTION	Indicates a potential hazardous situation which, if not avoided or prepared protection measures, may result in minor or moderate injury.
NOTICE	Indicates a potential hazardous situation which, if not avoided or not prepared protection measures, may result in property damage.

1.3. Notation and Meaning of Important Information

Notation	Meaning
NOTE	Important maters or useful information for the SG operation, maintenance and inspection.

Chapter 2 OVERVIEW OF SG

2.1. Name of Each Part

Here is an explanation of the name of each part.

NOTE

The following drawings may not strictly represent the actual appearance of the product ordered.

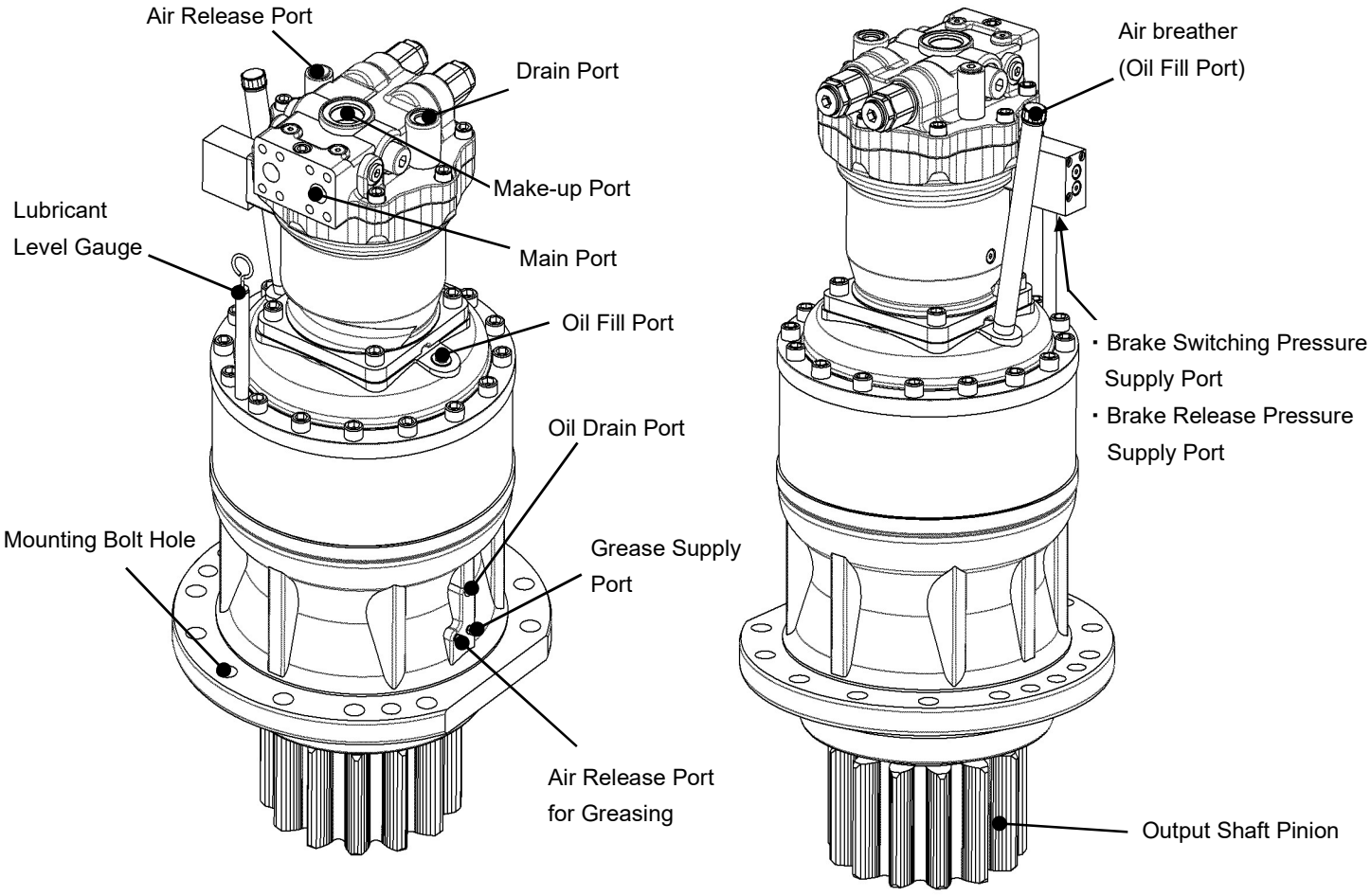


Fig. 2-1

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2.2. Storage of SG

NOTICE

When storing the product, follow the same packing condition as before unpacking.
If the packaging conditions change, foreign matter may enter inside or rust may occur.

To avoid rust, corrosion, and deterioration of seals, avoid storage in places such as:

- Places where the surrounding temperature is under -10°C or over 40°C (Temperature recommended as the storage environment)
- Places of high humidity
- Places with direct sunlight
- Places where dew may condensate or freeze
- Outdoors with wind and rain directly
- Places near chemical substances such as an organic solvent, acid, and alkali
- Places exposed to corrosive gas and/or dust
- Places with unstable flooring
- Places where the floor strength is insufficient
- Places under vibration

NOTE

When the product is used or re-operated after a long-term, check the following:

- **That there is no rust or corrosion;**
  Although SG has antirust oil applied to the outside before shipping, check the antirust state at least once a year. Take an antirust measure as necessary. The antirust state before shipping will be maintained for approx. twelve month.
- **That seal parts has not been deteriorated over time.**
- **That lubricant or grease has not leaked.**

Chapter 3 PREPARATION FOR INSTALLATION

3.1. Installation Environments

⚠ WARNING

The installation environments should be in compliance with those specified in confirmation notice (that is equivalent to delivery specification sheet) for this product or the specifications and operating agreement on the machinery for which this product is used. Also, please do not use under the following environmental conditions. Using SG out of the specified environmental conditions may result in serious physical injury or severe property damage.

- **Places exposed to seawater or underwater**
- **Places exposed to toxic gases that may cause metal corrosion**

3.2. Preparation of Necessary Materials

The installation of SG requires the following parts and materials.

Please prepare them after confirming the confirmation notice which includes installation drawing.

● Mounting bolt

Use the bolts required to mount SG with the maximum thickness that can be applied to drilled holes.
If there is anything uncertain, please contact our customer support.

● Hydraulic oil

A small amount of hydraulic oil remains in SG at the time of shipment. It remains in the process of shipping inspection and does not affect the performance of the product.

For detailed information on the hydraulic oil, refer to Chapter 5 (p.18) and the Safety Data sheet. For the Safety Data sheet, contact our customer support or the supplier of the hydraulic oil.

● Lubricant, Grease

SG is filled with the lubricant and grease specified by our corporation at the factory.

For detailed information on the lubricant and grease, refer to Chapter 5 (p.18) and the Safety Data sheet. For the Safety Data sheet, contact our customer support or the supplier of the lubricant and grease.

3.3. Transportation and Unpacking

3.3.1 Transportation

WARNING

- **The mass of SG is heavy. Be sure to use transportation equipment such as a forklift to transport SG units.**
- **In transporting SG, handle it with ample care to avoid drops or falls. Otherwise it may result in injuries of the operator or damage to SG.**
- **For the personnel who carry out transportation, at least observe the following condition and wear the protective gear.**
  - **A forklift must be operated by a qualified person.**
  - **Be sure to wear a helmet, leather gloves and protective footwear.**
- **Be sure to check that SG is in the correct vertical orientation before unpacking the package. If it is turned upside down, the packaging material may be damaged, and SG may jump out and cause injury to workers.**

- **SG weight**

Refer to the confirmation notice.

3.3.2 Unpacking

NOTICE

Since SG has antirust oil applied to the outside before shipping, it may be slippery.
Wipe off the antirust oil before operation.

NOTE

- **The drawings in this manual do not necessarily represent the individual packaging or the product. They change by the individual product or the confirmation notice. Also, for convenience, the drawings are cut out of the packaging material so that the contents can be imaged.**
- **Reduction gear of SG is filled with lubricant specified by our corporation at the factory.**
  (The product may not be filled with lubricant and grease depending on the contents of the order. See the confirmation notice to check the details.)
- **When hoisting SG, refer to the Hoisting SG section (Sections 4.1 and 4.2 on p.14 and p.15).**

[Packing example]

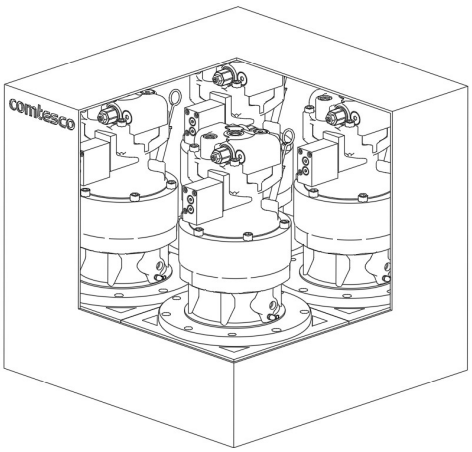


Fig. 3-1

- **Confirmation of contents**

Confirm the following before using the product:

Please contact our customer support if there is any delivery error or damage.

- The confirmation notice number matches the MS number on the nameplate, and the type code shown on the confirmation notice matches the type code shown on the nameplate. (Refer to nameplate contents p.13)
- There was no breakage during transportation. (Refer to the confirmation notice.)
- Check the confirmation notice and SG, there was no missing of the bolts by visual confirmation.

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NOTE

At the time of delivery, covers or plugs are attached to ports of the product to prevent contamination from entering inside. (They are not shown in the confirmation notice.) Do not remove it during storage, and remove it when connecting pipes.

- **Confirmation of lubricant**

Refer to Replacement procedure (p. 22) in Sections 5.5 Replacing Lubricant. And check that the lubricant is filled by using the level gauge. (The product may not be filled with lubricant depending on the contents of the order. See the confirmation notice to check the details.)

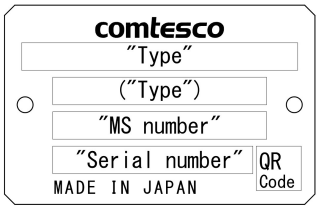
- **Labeling**

The nameplate is attached on the body of SG.

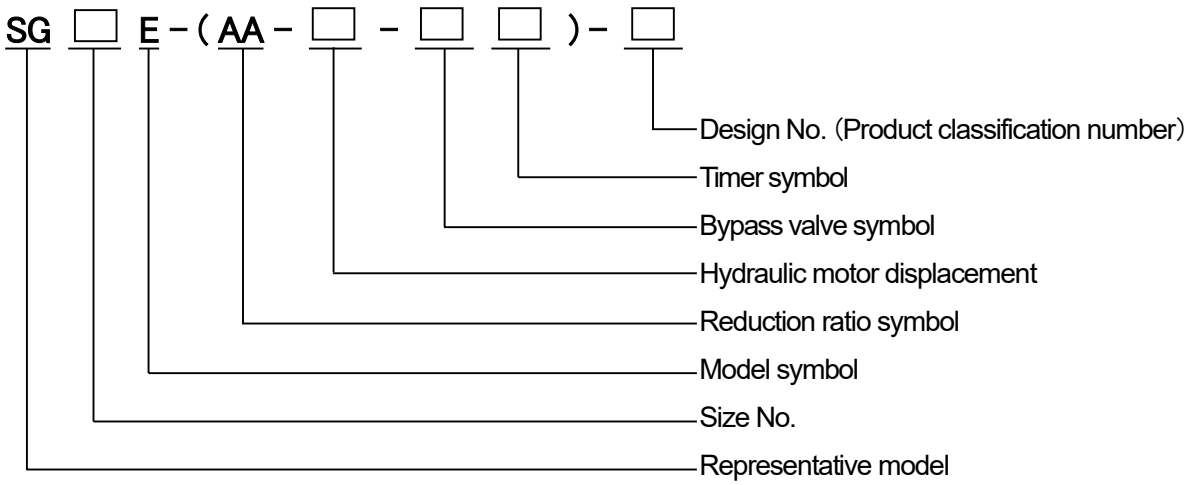
It indicates the product type, and others.

The type information includes the following product information.

＜Nameplate example＞



＜Indication example of standard product type＞



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Chapter 4 INSTALLATION IN THE MACHINE

4.1. Precautions on Hoisting

⚠ CAUTION

- The crane operation during hoisting must be conducted by a qualified person.
- Be sure to wear a helmet, leather gloves and protective footwear during hoisting work.
- The mass of SG is heavy. Use a hoisting tool robust enough to endure the mass of SG.
  If the strength of the hoisting tool is insufficient, the tool may be damaged and/or drop SG.
- Never get under SG while it is being hoisted.

⚠ WARNING

Hoist SG body horizontally in a balanced manner. If it loses its balance and falls, operators may be injured or the customer's machine and SG may be damaged.

4.2. Hoisting and Installing SG

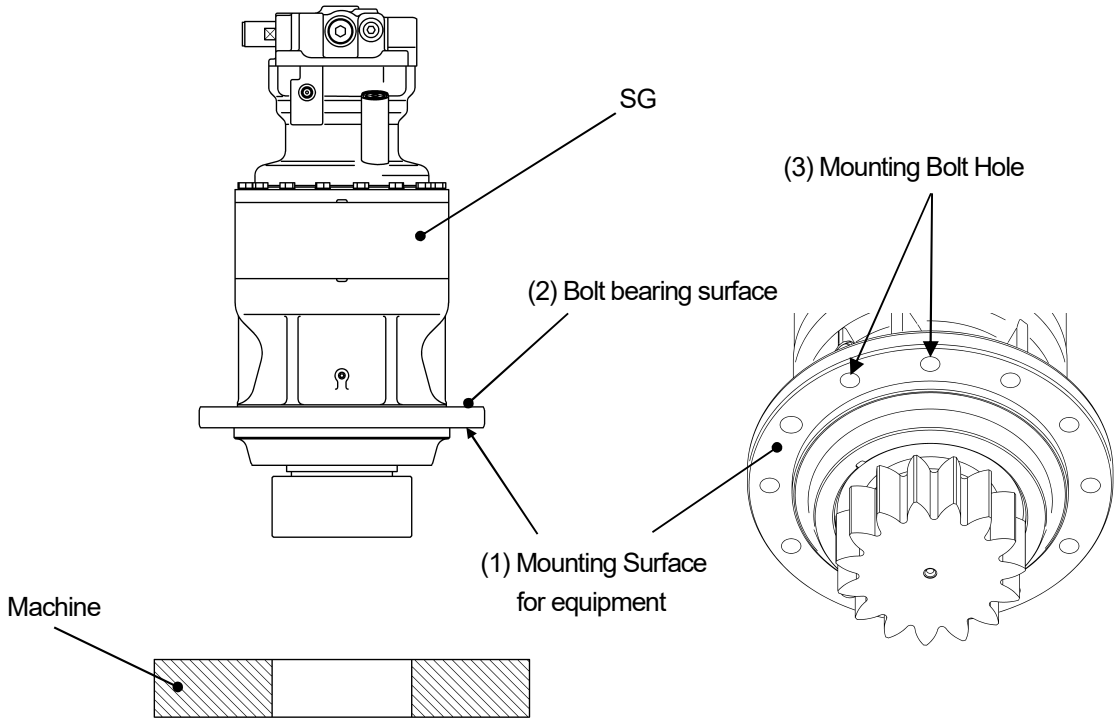


Fig. 4-1

Step 1 Attach the hoisting tool to SG.

NOTE

When hoisting SG, be sure to attach a clean hoisting tool to the makeup port and handle SG via the hoisting tool.

Step 2 Hoist SG body.

Step 3 Check that there are no burrs or dirt on (1) Mounting Surface for equipment of SG and SG mounting surface of the machine, and wipe off the antirust oil on (1) Mounting Surface for machine of SG and (2) Bolt bearing surface of SG.

NOTE

SG has antirust oil applied to the non-painted surfaces before shipping. To keep the transmitting torque by bolts high, wipe off the antirust oil on the mounting surface sufficiently.

Step 4 Align (3) Mounting Bolt Holes of SG with the mounting holes of the Machine, make the Output Shaft Pinion engage with the rotary ring to install SG into the Machine.

NOTICE

During the installation, do not hit SG with a hammer and the like.

Step 5 Insert the flat washers and the mounting bolts into (3) Mounting Bolt Holes of SG.

NOTICE

Use the specified number of SG mounting bolts and tighten with the specified tightening torque. Otherwise, not only SG may not provide its performance but also the customer machine and SG may be damaged.

Step 6 Tighten the mounting bolts for equipment uniformly with the specified tightening torque. Refer to the confirmation notice for the quantity and bolt size.

Table 4-1 Bolt tightening torque

Bolt size	M14(P2.0)	M16(P2.0)	M20(P2.5)	M24(P3.0)
Tightening torque[N-m] (Recommendation)	163±24.5	252±39.2	493±78.5	709±88.3

4.3. Hydraulic Piping Connection

After installing SG, connect hydraulic pipings.

Step 1 Remove the covers or plugs attached to the port.

Step 2 Fill the motor casing with hydraulic oil. Refer to the confirmation notice for the amount of hydraulic oil.

NOTICE

Fill the motor casing with hydraulic oil before use. If SG is operated without supplying hydraulic oil, the product may be damaged.

Step 3 Connect each hydraulic pipe.

NOTICE

- **Confirm SG piping port, rotation direction, and piping size in the confirmation notice.**
- **Select the piping size so that the drain port back pressure is below the pressure described in the confirmation notice.**
- **Refer to the confirmation notice for setting the hydraulic timer.**
- **Provide the makeup port with a back pressure check valve on the return side of the control valve to supply a pressure that prevents the occurrence of cavitation when the motor stops.**
- **The shockless relief valve may not work properly depending on the pressure applied. See the confirmation notice to check the details.**

4.4. Trial Run after Installation

After installing SG on the customer machine and piping it, check that the rotating direction is the intended direction. Also, follow the note below and operate safely after running-in SG.

NOTE

In the running-in operation, use the engine of the machine in low idling and keep idling for 5 minutes or more to remove the inside air with SG at low speed.

⚠ CAUTION

- **Never approach the rotating part during machine operation. Person(s) may be caught by the rotating part, causing fatal accidents.**
- **SG may become hot during operation. After stopping the operation, do not touch SG until it has cooled down.**
- **Immediately stop operation when any abnormality occurs. Continuous operation may cause injuries to the operator.**
- **Observe SG specifications and the limitation of specifications specified by us. (Specifications and the limitation should be in compliance with the confirmation notice for SG or the specifications and operating agreement for the machine for which SG is used.)**

NOTICE

Do not perform rapid cooling for high-temperature SG. When cooling, perform air cooling by atmospheric air.

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Chapter 5 HYDRAULIC OIL, LUBRICANT AND GREASE

This chapter describes hydraulic oil, lubricant and grease. The description on hydraulic oil, lubricant and grease (this chapter) in this document should be reflected at least to the operation manual for the customer's machine into which SG is incorporated.

⚠ CAUTION

- **When replacing the hydraulic oil, lubricant and grease, turn off the power to the customer machine.**
- **SG may become hot during operation. After stopping the operation, do not touch SG until it has cooled down. If the oil fill port, oil drain port, grease supply port and air release port for greasing are unplugged in the high-temperature state, the high-temperature lubricant may blow out accidentally due to the pressure change in the reduction gear, which can cause burn injury.**

NOTICE

- **SG is filled with the lubricant and grease at the factory. Filling up the lubricant or grease excessively may result in heat generation and leakage of the lubricant. (The product may not be filled with lubricant and grease depending on the contents of the order. See the confirmation notice to check the details.)**
- **SG is drained hydraulic oil at the time of shipment. Be sure to fill the motor casing with hydraulic oil before operation.**
- **If the amount of the lubricant or grease has decreased due to some reason, identify and remove the cause, and then add the lubricant.**
- **When draining the lubricant, do not drain it on the ground. Be sure to drain it into a container. Disposal of the waste oil should be in accordance with the applicable laws and regulations.**
- **Do not perform rapid cooling for high-temperature SG. When cooling, perform air cooling by atmospheric air.**

5.1. Precautions when Handling Hydraulic Oil, Lubricant and Grease

● Precautions when handling hydraulic oil, lubricant and grease are as follows:

- Before handling hydraulic oil, lubricant and grease, be sure to read the precautions described on the case/bottle of each lubricant for correct use. Wrong usage may cause fatal accident.
- Be sure to wear protective goggles in order to prevent hydraulic oil, lubricant and grease from entering into eyes.
- Be sure to wear rubber gloves to prevent hydraulic oil, lubricant and grease from contacting your skin.
- Do not ingest hydraulic oil, lubricant, or grease.
- For detailed information, refer to Safety Data Sheet of hydraulic oil, lubricant and grease.
  Ask to the Safety Data Sheet from our Customer Support or the purchaser of hydraulic oil, lubricant and grease.

- **Emergency measure:**
  - If hydraulic oil, lubricant or grease comes into contact with eyes, flush for 15 minutes with clean water and seek medical treatment.
  - If hydraulic oil, lubricant or grease comes into contact with skin, wash affected area with water and soap.
  - If hydraulic oil, lubricant or grease is swallowed, do not induce vomiting and seek medical treatment immediately.
- **Disposal of waste oil and container:**
  - Proper disposal is required by laws and regulations. Follow the laws and regulations.
  - Consult the purchaser of hydraulic oil, lubricant and grease for assistance or advice if any uncertainty arises.
- **Storage**
  - To avoid any foreign object or water from being mixed in, seal container of hydraulic oil, the lubricant and grease after use.
  - Avoid direct sun light, keep away from fire or heat sources, and store in a cool and dark place.

5.2. Type of Hydraulic Oil

NOTICE

Use the hydraulic oil recommended by us. Use of any other hydraulic oil may degrade the performance and durability of SG.

- **Hydraulic oil specified by Comtesco**
  - Use a wear-resistant hydraulic oil with a viscosity equivalent to ISO VG32 to VG46.
  - The cleanliness of hydraulic oil should be maintained within level NAS9.
  - The recommended brands are as follows.

Grade	Viscosity (40 [℃])	32 [mm^2/s]	46 [mm^2/s]
	JIS	VG32	VG46
Manufacturer name	Idemitsu Kosan	Daphne Super Hydro A32	Daphne Super Hydro A46
	Exxon Mobil	Mobil DTE24	Mobil DTE25
	ENEOS	SUPER HYRANDO 32	SUPER HYRANDO 46
	Cosmo Oil	Cosmo Hydro AW32	Cosmo Hydro AW46

- **Filling volume of hydraulic oil**

  Prepare hydraulic oil according to the amount of hydraulic oil described in the confirmation notice.

- **Temperature and viscosity range of hydraulic oil**

  Make sure that the operating temperature range and viscosity range of the hydraulic oil do not exceed the following ranges.

  - Operating temperature range : -20～+90 [℃]
  - Practical viscosity range : 15～500 [mm^2/s]

NOTICE

When using with a viscosity of 500 [mm^2 / s] or more, the motor may not be able to suck oil and may cause malfunction. In addition, if the viscosity is less than 15 [mm^2 / s], the performance will decrease significantly, and if it is used for a long time, the motor sliding part may get damaged, resulting in a permanent deterioration in performance.

5.3. Replacing Hydraulic Oil

- **Replacement interval**

  - Replace with new oil every 1000 engine hours or 1 year.
  - If the deterioration of the hydraulic oil is severe even within the above replacement interval, replace it according to the following standard.

Test items		Replacement criteria
Viscosity change (40[℃])	[mm^2/s]	Within ±10[%]
Total oxidation	[mgKOH/g]	Consult with the hydraulic oil manufacturer because it depends on the oil type and manufacturer.
Water content	[%]	Within 0.1
Impurities	[mg/100mL]	Within 10
Insoluble content	[%]	Within 0.05
Color	—	Drastic change

- **Replacement procedure**

  Replace and replenish according to hydraulic oil replacement and replenishment procedure of the machine.

NOTICE

Use the same hydraulic oil brand for replacement and replenishment, and do not mix different brands.

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5.4. Type of Lubricant and Filling volume

Depending on the contents of the order, the reduction gear is lubricated with hydraulic oil, not with lubricant. In this case, this Section and Section 5.5 of this operation manual does not apply.

NOTICE

Use the lubricant recommended by us. Use of any other lubricant may degrade the performance and durability of SG.

- **Lubricant specified by Comtesco**

Use a lubricant with extreme-pressure additive equipment to SAE # 90 (API class GL-4 or higher).The following brands are recommended.

Manufacturer name	Product name
ENEOS	Gear Oil GL-4 90
Idemitsu Kosan	Apolloil Gear HE90
Exxon Mobil	Mobilube HD80W-90
Shell	Shell Spirax EP90
Cosmo Oil	Cosmo Gear GL-4 90

- **Filling volume lubricant**

Prepare lubricant according to the amount of lubricant in the confirmation notice.

- **Temperature range of lubricant**

Operating temperature range : -20 ～+80 [℃]

5.5. Replacing Lubricant

● Replacement interval

- Replace with new oil at 250 engine hours first, after that every 1000 engine hours. Replace the lubricant if it has been in stock for a long time (1 year or more).
- If the lubricant deteriorates severely even within the above replacement interval, replace it according to the following standard.

			Replacement	Apply
Viscosity change (40[℃])		[mm^2/s]	Within 10% compared with new oil	・Progress of oxidative degradation ・Mixing of different oil types
Water content		[%]	Within 0.2	External contamination
Pentane insoluble matter		[%]	Within 1.0	Oxide, carbon, additives, wear powder, dust, and so on. from outside
Total oxidation		[mgKOH/g]	0.5 increase compared with new oil	Progress of oxidative degradation
Metal analysis	Al	[ppm]	Within 150	
	Cr	[ppm]	Within 20	
	Cu	[ppm]	Within 20	
	Fe	[ppm]	Within 600	
	Si	[ppm]	Within 350	

● Replacement procedure

⚠ CAUTION

- **Confirm that the power of the customer machine is turned off before beginning the replacement work.**
- **Immediately after operation, SG and lubricant may be hot and may cause burns if touched. Work after the temperature has dropped sufficiently.**
- **Lubricant may eject when removing the reduction gear plug to supply and drain oil. Please work with great care, such as slowly removing the plug to relieve internal pressure.**
- **Be sure to wear protective goggles and rubber gloves.**
- **Do not replace/replenish the lubricant in a subfreezing environment. Failure to observe this may result in cold injury. Also, if the lubricant is replaced/replenished in a subfreezing environment, the temperature difference from the operating temperature increases and the pressure increase in the reduction gear may cause oil leakage.**

NOTICE

Do not perform rapid cooling for high-temperature SG. When cooling, perform air cooling by atmospheric air.

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NOTICE

Use the same lubricant brand for replacement and replenishment, and do not mix different brands.
When changing the oil type, flush the inside of reduction gear.

Replace or replenish the lubricant according to the following procedure. Also, work with SG in the posture with the oil fill port up and the oil drain port down as shown below.

※If it is impossible to put it in the posture shown in the figure below, drain all the lubricant referring to the following steps, and then supply the amount of filled lubricant described in the confirmation notice.

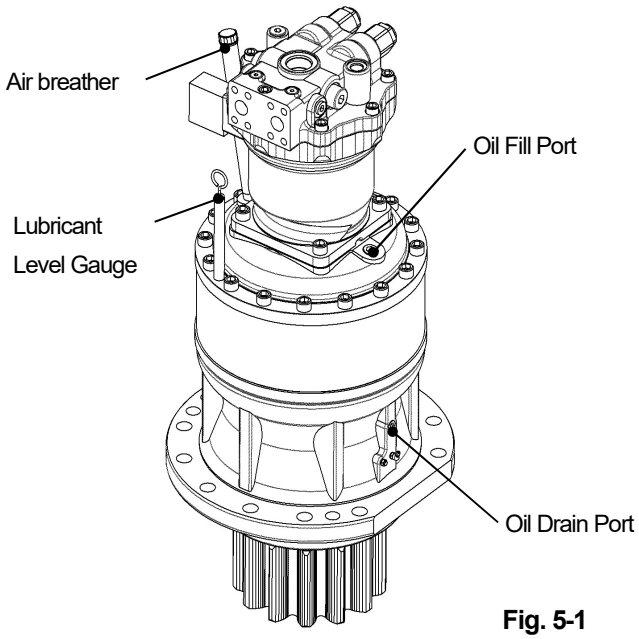


Fig. 5-1

Step 1 When replacing, remove the plug of the Oil Fill Port and Oil Drain Port, and drain the lubricant. When replenishing the lubricant, do not remove the plug of the Oil Drain Port.

NOTICE

- **Receive the drained lubricant with a container.**
- **If there is sealing tape on the tapered screw hole after removing the plug, remove it completely.**

Step 2 After the completion of drainage, plug the Oil Drain Port, and tighten the plug with the specified tightening torque (p.24 Table 5-1).
(Refer to the confirmation notice for plug size.)

Step 3 Referring to the amount of filled lubricant described in the confirmation notice, supply lubricant from the Oil Fill Port or the Air breather.
In the case of replenishment, the required amount is not clear. Therefore, supply lubricant little by little in such a way that the level of lubricant will be somewhere between the upper and lower limits of the Lubricant Level gauge.



NOTE

If the lubricant is filled up excessively, the inner pressure increases, which can cause a leakage of the lubricant or damage to the oil seal.
When the lubricant is small in amount, insufficient lubrication may cause damage to SG.

Step 4 Check the oil level with the Lubricant Level Gauge, insert the plug into the Oil Fill Port, and tighten with the specified tightening torque. (Refer to the confirmation notice for the plug size.)

Table 5-1 Plug size and tightening torque

Size	G3/8 or R3/8	R1/2	R3/4	G1/2
Tightening torque [N-m]	39 ± 4	44 ± 4	69 ± 7	49 ± 5

NOTICE

- **When tightening the plug with O-ring to each port, make sure that the O-ring is not damaged.**
- **After checking that the R plug is clean, wrap it properly with new sealing tape and then assemble it.**

Step 5 If the lubricant has adhered to the periphery, wipe it off sufficiently.

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5.6. Type of Grease

- When the product is delivered, the output shaft bearing in the reduction gear is filled with grease.
- Depending on the contents of the order, the output shaft bearing may be lubricated with hydraulic oil, not with grease. In this case, this Section and Section 5.7 of this operation manual does not apply.

- **Grease recommended by Comtesco**

Use lithium soap-based grease (NLGI consistency grade 2).

5.7. Replenishment of Grease

- **Replenishment interval**

Replenish grease at 250 engine hours first, after that every 1000 engine hours.

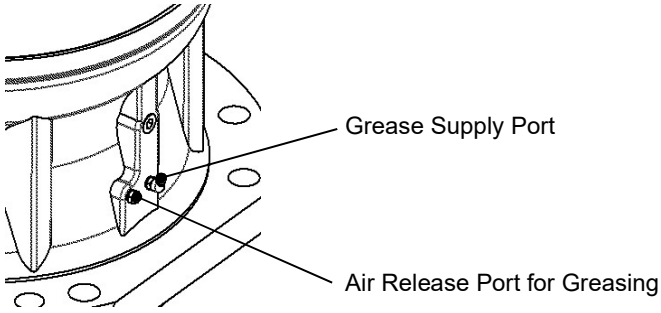
⚠ CAUTION

When supplying grease, make sure to stop the engine and wait until the temperature of the case becomes sufficiently low.

NOTICE

Open the plug of the Air Release Port for Greasing before injecting grease. Failure to do so may damage the oil seal of the reduction gear due to internal pressure.

Follow the steps below to replenish grease.



Step 1 Loosen and remove the plug of the Air Release Port for Greasing.

Step 2 If the Grease Supply Port is closed with a plug, loosen the plug and replace it with a joint that enables you to supply grease, such as a grease nipple.

Step 3 Keep supplying grease with a grease gun or the like until the grease is pushed out of the Air Release Port for Greasing.

Step 4 If the Grease Supply Port of the product is closed with a plug, remove the grease nipple. Then insert the plug and tighten it with the specified tightening torque.

Step 5 After wiping the grease discharged from the Air Release Port for Greasing, insert the plug into the Air Release Port for Greasing, and tighten it with the specified tightening torque to close the port.

Table 5-2 Plug size and tightening torque

Size	R1/8	G1/4 or R1/4
Tightening torque [N-m]	20 ± 3	29 ± 5

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Chapter 6 MAINTENANCE & INSPECTION

This chapter describes the maintenance and inspection. Reflect at least the description on maintenance & inspection (this chapter) in this document to the operation manual for the customer machine into which SG is incorporated.

6.1. Precautions on maintenance and inspection

⚠ CAUTION

- **Turn off the power to the customer machine before starting maintenance and inspection. If maintenance or inspection is performed during machine operation, person(s) may get burned due to high temperature or be caught by the rotating part, causing fatal accidents.**
- **Do not perform maintenance and inspection in a subfreezing environment. Failure to observe this may result in cold injury. Also, if maintenance or inspection is performed in a subfreezing environment, the temperature difference from the operating temperature increases and, as the result, the increased pressure in the reduction gear may cause oil leakage.**
- **SG may become hot during operation. After stopping the operation, do not touch SG until it has cooled down.**
- **Wear appropriate clothing and appropriate protective equipment (protective goggles, protective gloves, and protective footwear).**
- **Abnormal noise should be checked during operation. Never touch the machine during the check.**

NOTICE

Do not perform rapid cooling for high-temperature SG. When cooling, perform air cooling by atmospheric air.

6.2. Periodical Inspection

● Periodical inspection list

Inspect the following items at least once in a year.
Lubricant must be replaced based on the operating time. Refer to Section 5.5 Replacing Lubricant (p.22) and replace as appropriate. For hydraulic oil, replace it appropriately referring to Section 5.3 Replacing Hydraulic Oil (p.20).

No.	Inspection item	Description	Reference
1	Leakage of lubricant and grease	Check whether there is not a leakage of lubricant and grease from the mating surface around SG and oil seal section.	6.2.1.
2	Bolt looseness	Check whether each mounting bolt is not loose.	6.2.2.
3	Abnormal noise	Check whether there is not any abnormal noise or sudden change in sound.	6.2.3.
4	Surface temperature of SG	Check whether surface temperature of SG is abnormally high.	6.2.4.

- **Necessary tools**

The typical tools required for maintenance and inspection are listed below.

- Hexagon wrench
- Wrench
- Torque wrench
- Surface thermometer

6.2.1. Checking for lubricant and grease leakage

Visually check the periphery of the reduction gear, joint surface with the machine, and the entire machine to make sure that there is no leakage of the lubricant and grease.
If a leakage of the lubricant or grease has been found, identify and remove the cause, and then replenish the lubricant or grease.

NOTICE

The adhering dirt and sand may cause seizure, heat generation, or protrusion, and the lubricant may leak due to the loss of the sealing performance of the oil seal.

6.2.2. Inspecting the mounting bolts

Check looseness of the mounting bolts for machine. If any are loose, retighten with the specified tightening torque. (Refer to Table 4-1 on p.16 for the tightening torque.)

6.2.3. Checking for abnormal noise

⚠ CAUTION

Abnormal noise should be checked during operation. Never touch the machine during the check.

Step 1 Be careful not to touch SG and check abnormal noise or sudden changes in sound.

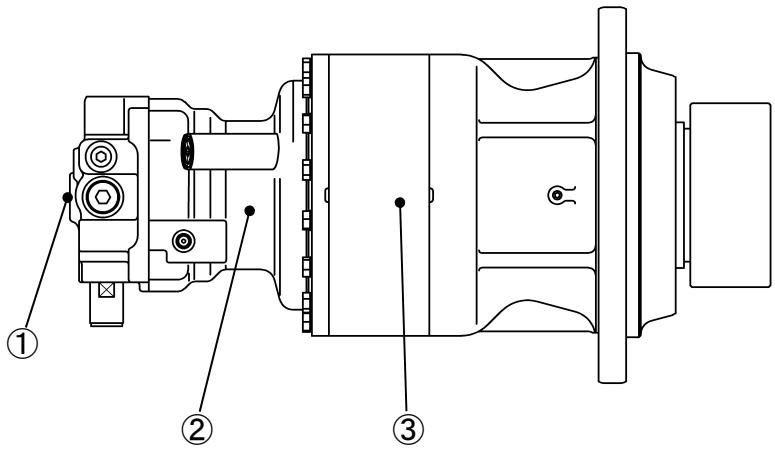
Step 2 If any abnormal noise or sudden change in sound has been detected, report it to the administrator and stop the machine operation.

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6.2.4. Inspecting the surface temperature

Measure the surface temperatures of the motor and reduction gear to check whether they are not over the standard temperature. Measure the surface temperature after about 5 minutes of warm-up (continuous operation).

Step 1 Using a surface thermometer, measure the surface temperature at the measurement point shown in the following figure below and the surrounding area to check the maximum value.



① : Control valve
② : Hydraulic motor
③ : Reduction gear
※②, ③ anywhere on the circumference

Fig. 6-2

NOTE

For the method of using the surface thermometer, refer to the operation manual attached to the product you use.

Step 2 If the surface temperature is more than the Standard surface temperature below, report it to the administrator and stop the machine operation.

Standard surface temperature of hydraulic motor and reduction gear in continuous operation : Oil temperature +20℃

6.3. Removal from the Machine

If it is necessary to remove SG from the machine for maintenance, inspection, or replacement, pay the following precautions and remove it in the reverse procedure described in Section 4.2, Hoisting and Installing SG (refer to p.15).

⚠ CAUTION

- **To remove SG, hoisting by crane operation is needed. Before starting the removal, refer to "4.1 Precautions on Hoisting" (p.14) to confirm the precautions on hoisting and work procedure. Hoist SG in accordance with the description.**
- **Make sure no torque remains on SG before starting work.**

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Chapter 7 TROUBLESHOOTING

If there is any problematic phenomenon, check the cause and take measures according to the following table.
If the measure marked with a circle is needed, stop the machine operation and contact our customer support.

For the item marked with a circle, contact our customer support. ↓

Phenomenon 1	Phenomenon 2	Possible cause	Countermeasure	
Does not rotate	No pressure is applied	Low set pressure of the relief valve	Set the pressure correctly.	
		Malfunction of the pump	Replace or repair.	
		Malfunction of the direction-switching valve	Replace or repair.	
	Pressure is applied	Malfunction of the control valve	Replace or repair the control valve.	○
		Malfunction of the hydraulic motor	Replace or repair.	○
		Damage of the gears	Replace gears.	○
		Overloaded	Remove the load.	
Oil leakage	From the mating surfaces	Scratches on mating surfaces	Polish the surface using a grindstone, polishing paper, and so on.	○
		O-ring damage	Replace the O-rings.	○
		Looseness of bolts	Retighten the bolts.	
	From the case	Looseness of plugs	Retighten the plugs.	
		Damage of the parts	Replace applicable parts.	○
	From the Oil seal	Lip damage, seal slippage	Replace the Oil seal.	○
	From the hydraulic motor	Looseness of bolts	Retighten the bolts.	
		O-ring damage	Replace the O-rings.	○
Rotated by load during use	Increased internal or external drain	Scratches on the sliding surface and the sealing surface	Replace applicable parts.	○
		Reduced volumetric efficiency of the hydraulic motor	Replace or repair the hydraulic motor.	○
		Increased internal leakage (drain) of the control valve	Replace or repair the control valve.	○
	Mechanical brake is not working	Damage to springs	Replace the springs.	○
		Friction plate or mating plate wear	Replace the friction plate and the mating plate.	○

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Phenomenon 1	Phenomenon 2	Possible cause	Countermeasure	
The surface temperature of the reduction gear is high		Lack / excess of lubricants	Adjust oil level.	
		Damage of the bearing	Replace the bearing.	○
		Damage of the gears	Replace gears.	○
		Hydraulic oil enters the gear case	Replace the oil seal and lubricants.	○
Speed is insufficient	Low pump discharge	Malfunction of pump	Replace or repair the pump.	
		Reduced volumetric efficiency of the pump	Replace or repair the pump.	
	Low hydraulic motor rotation	Reduced volumetric efficiency of the hydraulic motor	Replace or repair the hydraulic motor.	○
Abnormal noise is produced.	From SG	Damage to the hydraulic motor or reduction gear	Replace SG.	○
	From the pipe	Vibration of pipes	Clamp the pipes.	

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CUSTOMER SUPPORT

For inquiries related to products and servicing, please contact customer support (see the following addresses):

For inquiries, be ready to provide the product information described on the nameplate attached on the product.

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